

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020467**Date Inspected:** 26-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#10

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW):

Repair welding of a weld joint # 13 located on Traveler rail 20TR2-030 as per the weld repair report #

B-WR14293. Welder is identified as 040434. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 1G (1F) – ESAB – REPAIR.

Repair welding of a weld joint # 17 located on Traveler rail 20TR2-030 as per the weld repair report #

B-WR14295. Welder is identified as 040458. ZPMC Quality Control (QC) Inspector is identified as Deng Zhi

Bing. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 1G (1F) – ESAB – REPAIR.

Repair welding of a weld joint # 09 located on Traveler rail 20TR2-030 as per the weld repair report #

B-WR14292. Welder is identified as 044473. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The

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welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 1G (1F) – ESAB – REPAIR. (See attached photo)

Repair welding of a weld joint # 15 located on Traveler rail 20TR2-030 as per the weld repair report # B-WR14294. Welder is identified as 040458. ZPMC Quality Control (QC) Inspector is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 1G (1F) – ESAB – REPAIR.

BAY#14

This QA Inspector observed the following work in progress  
Submerged Arc Welding (SAW):

Weld joint #009 located on 13BW, SEG3014. Welder is identified as 045270. ZPMC Quality Control (QC) Inspector is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2)1T-ESAB-1. (See attached photo)

Shielded Metal Arc Welding (SMAW):

Weld joint #256 located on 13CW, DP3148-001. Welder is identified as 037840. ZPMC Quality Control (QC) Inspector is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-Tc-U4b-FCM.

Repair welding of a weld joint #293 located on 13CW, SEG3015F as per the weld repair report # B-WR20190. Welder is identified as 037932. ZPMC Quality Control (QC) Inspector is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-Repair-1.

Weld joint #045 located on 14W, SEG3020AY. Welder is identified as 067609. ZPMC Quality Control (QC) Inspector is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-Tc-U4b-FCM.

Repair welding of a weld joint #001 located on 14W, SEG3020BB as per the weld repair report # B-WR20146. Welder is identified as 067942. ZPMC Quality Control (QC) Inspector is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-Repair-1.

Weld joint #118 located on 14W, DP3169 – 001. Welder is identified as 037779. ZPMC Quality Control (QC) Inspector is identified as Shao Jian Yuan. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-Tc-U4b-FCM.

Weld joint #412 located on 14W, DP3171 – 001. Welder is identified as 069493. ZPMC Quality Control (QC) Inspector is identified as Shao Jian Yuan. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-Tc-U4b-FCM.

Flux Cored Arc Welding (FCAW):

Weld joint #186 located on 14W, SEG3020W. Welder is identified as 066236. ZPMC Quality Control (QC) Inspector is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the

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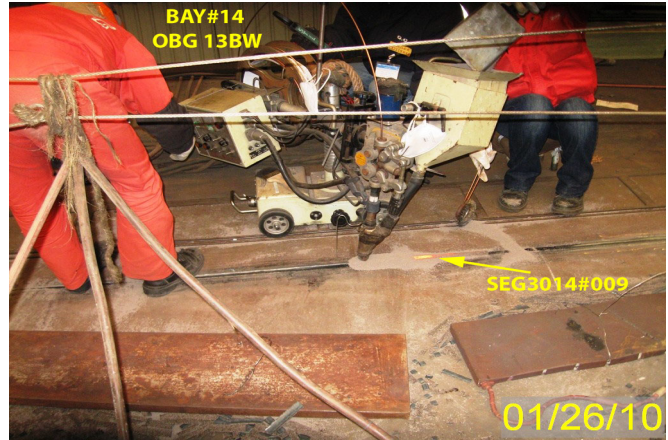
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WPS-B-T-2231-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho- 15002048250, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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